Job Number Prsht Rev. Written By

Tuesday, 08/04/2008 12:53:00 PM

Julie Lecocq

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

: 38469

Estimate Number

: 13162

P.O. Number

This Issue

: 08/04/2008 : NC

: // First Issue

Previous Run

: 37297

: SMALL /MED FAB Type

S.O. No. :

Part Number

Drawing Name

Drawing Number

- D3733 REVA

Project Number Drawing Revision : N/A

Material

Due Date

: 15/04/2008

: GUSSET

: D37331

Qty:

8 Um:

Each

Checked & Approved By

Comment

08-01-30 new issue DD verifyed by:EC : Est Rev:A

DD verified by: 08-03-19 ecn 1158 Est Rev:B

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M6061T6S125

6061-T6 .125 Sheet



Comment: Qty.:

0.0292 sf(s)/Unit Total:

0.2335 sf(s)

6061T6 aluminium .125" thick

(M6061T6S125)

Batch:

2.0 WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3733

Dwg Rev:_

Prog Rev: _____



2- Deburr if necessary

3.0

QC2

9-4-8

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK



Comment: SECOND CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1







Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr if necessary



Dart Aerospace Ltd

W/O:			WORK ORDER	CHANGES				
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
Part No	:	PAR #:	Fault Category:	NCR: Yes No DQA:			Date:	
				QA	QA: N/C Closed:			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B	Verification						
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto			
					:						
	5										

NOTE: Date & initial all entries

Date: Tuesday, 08/04/2008 12:53:00 PM User: Julie Lecocq **Process Sheet Drawing Name: GUSSET** Customer: CU-DAR001 Dart Helicopters Services Part Number: D37331 Job Number: 38469 Job Number: Seq. #: **Description: Machine Or Operation:** INSPECT WORK TO CURRENT STEP QC5 6.0 Comment: INSPECT WORK TO CURRENT STEP 7.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify wiith Dart part # using a fine point permanent marker and Stock Location: 266 FINAL INSPECTION/W/O RELEASE 8.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Ae	rospace	Ltd				•		
W/O:			V	ORK ORDER CHANGES			, , , , , , , , , , , , , , , , , , ,	
DATE	STEP	PROCEDURE CHANGE			Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						,		
Part No	:	PAR #:	Fault Cat	egory: N	CR: Yes	No DQA:	Date: _	
					QA: N	/C Closed:	Date: _	
NCR:			WORK ORI	DER NON-CONFORMANC	CE (NCR	R)		
		Description of NC		Corrective Action Section B		Verification	Annroyal	Ammroyeel
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector

NCR:											
		Description of NC		Corrective Action Section E	Varification	Approval Chief Eng	Approval QC Inspector				
DATE	STEP	Section A	Initial Chief Eng	Initial Action Description Sign & Section C	Verification Section C						
								· -			
***	·										

NOTE: Date & initial all entries

D3733-1 GUSSET

SUBJECT TO AMENDMENT WITHOUT NOTICE

UNCONTROLLED COPY

SHOP COPY RETURN TO ENGINEERING

NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.125)

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: N/A

7) WEIGHT: 0.02 lbs

NEW ISSUE À AJS 08.02.04 REV. DESCRIPTION BY DATE DESIGN AJS **DART AEROSPACE LTD** DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D3733 MFG. APPR. SHEET 1 OF 2 APPROVED TITLE SCALE GUSSET DE APPR. NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLED ON THE EXPRESS CONDITION THAT IT IS

NOT TO BE USED FOR ANY PURPOSE ON COPIED ON COMMUNICATED TO ANY OTHER PERSON WITHOUT

WHATTEN PERMISSION FROM DART AEROSPACE LTD. DATE 08.02.04

5

R0.03 TYP 1.96 2 PL 0.125 REF 0.25 X 45 CMF-**D3733-1 GUSSET** SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COLY DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA AJS SUBJECT TO AMENDMENT DRAWN WITHOUT NOTICE CHECKED DRAWING NO. REV. A D3733 MFG. APPR. SHEET 2 OF 2 APPROVED TITLE SCALE **GUSSET** DE APPR. COPYRIGHT © 2008 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS

NOT TO BE USED FOR ANY PURPOSE ON COPED ON COMMUNICATED TO ANY OTHER PERSON WITHOUT

WHITTEN PERMISSION FROM DAYS ARROSPACE LTD. DATE 08.02.04 5

DART AEROSPACE LTD	Work Order: 384 69
Description: (FUSSET	Part Number: D3733~
Inspection Dwg: 03733-1 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

+1	<u> </u>	First Artic	cie _				
Drawing Dimension	Tolerance	Tolerance Actual Accept		Reject	Method of Inspection	Comments	
1175	4- ,010	.122	X				
1.96	4- 630	1.96					
1,96	+/- 1030	(96					
		- : :					
						<u> </u>	
						•	
				-			
			1				
					· · · · · · · · · · · · · · · · · · ·		
						•	
						•	
				<u> </u>			
				·			
<u> </u>							
			•		<u> </u>		
					<u> </u>		
					<u> </u>		
		<u> </u>		-			
		T P					
					<u> </u>		
	<u> </u>					· •	
sured by:	B Au	idited by:	,	Prot	otype Approv	al:	
	8-48		du 107	1	Da		
		D	214 lat				
Date	Change				Revis	ed by Approved	



KJ/JLM

New Issue